

(8)

Dart Aerospace Ltd.

Date: Monday, 5/15/2006 11:11:57 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206  
 Job Number : 27111  
 Estimate Number : 10821  
 P.O. Number : **N/A** Part Number : D26662  
 This Issue : 5/15/2006 S.O. No. : **N/A** Drawing Number : D2666 REV. B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 5/15/2006 Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 25981 Material : **N/A**  
 Written By : See Due Date : 5/30/2006 Qty: 12 Um: Each  
 Checked & Approved By : JA 06.05.15 N  
 Comment : Est: C 0011.01 Removed P/O for Powder Coat - in house processEC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: **B25342**

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

2-Fixturing W/O No **N/A** - **Chd 06.06.27**

3-Fixturing Inspection last completed on \_\_\_\_\_ by \_\_\_\_\_

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

**JL/SA 06.06.19**

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

**JL/SA 06.06.19**

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

**JL/SA 06.06.19**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/06/26

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:11:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 27111

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*me 06/06/21 12*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*DL 06/06/22 (12)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*DL 06/06/22 (12)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*DL 6/6/23 (12)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 475*

*DL 6/6/23 12*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DL 06/06/26*

Job Completion



*U 06.06.12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>27111</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2666-2</b>
<b>Inspection Dwg:</b> D2666 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.118	.115	.119		
B	0.100	0.140		.119	.117	.115	.121		
C	0.100	0.140		.123	.123	.121	.121		
D	0.210	0.230		.218	.222	.225	.221		
E	1.245	1.255		1.251	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.251		
G	5.990	6.010		6.001	6.003	6.003	6.003		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.680	1.680	1.680	1.679		
J	2.495	2.505		2.499	2.500	2.501	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.239	.239		
N	0.100	0.140		.115	.120	.122	.120		
O	0.540	0.560		.549	.550	.551	.550		
P	0.490	0.510		.500	.500	.501	.500		
Q	3.609	3.619		3.614	3.614	3.614	3.613		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.250	.250	.250	.252		
T	0.100	0.180		.145	.148	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.132	1.136	1.137	1.137		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>JL</u>	Audited by: <u>PhL</u>
Date: <u>06/06/11</u>	Date: <u>06/06/21</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02:12:12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27111
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. B	<b>Page 1 of 1</b>

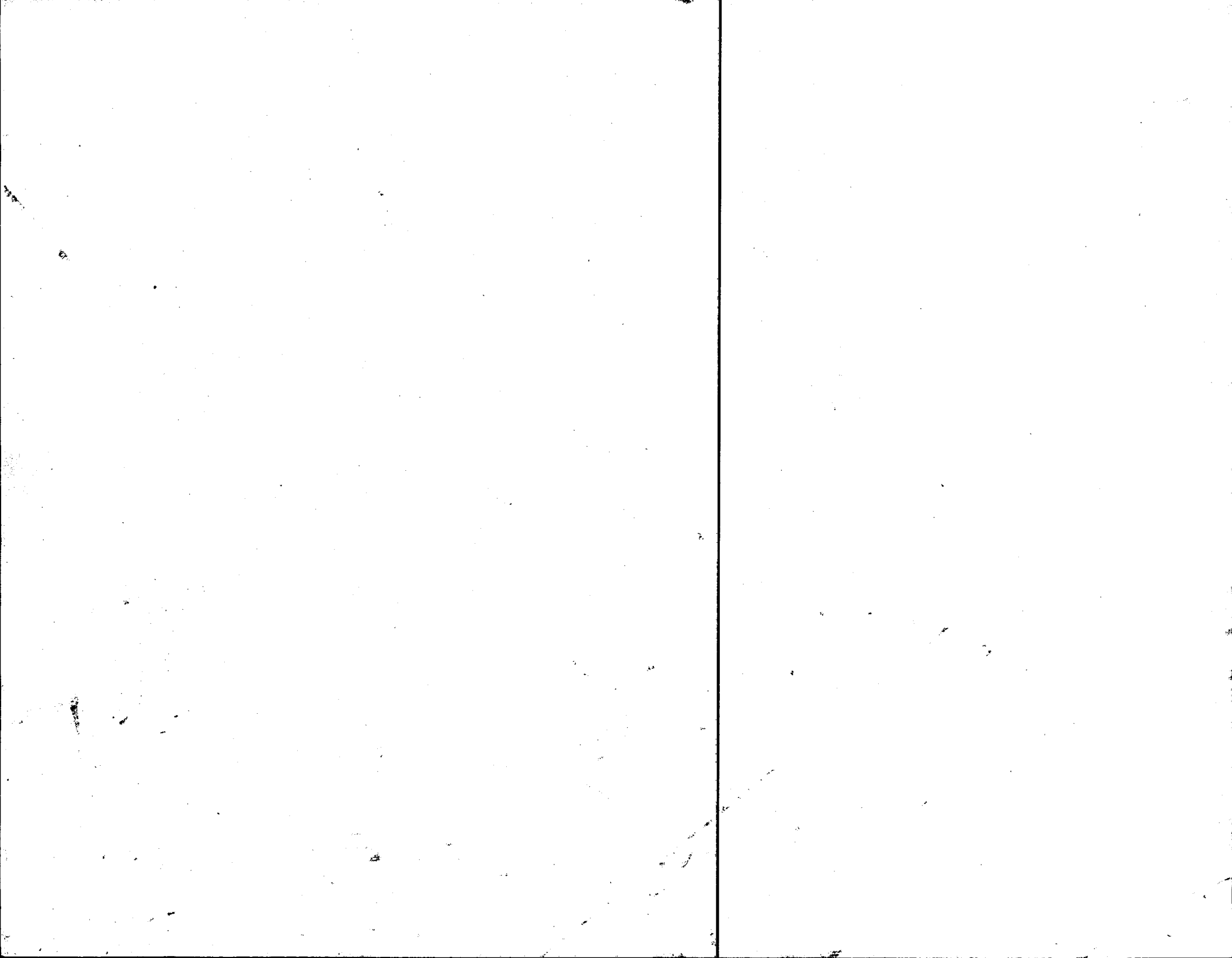
Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119	.119	.119		
B	0.100	0.140		.120	.120	.119	.120		
C	0.100	0.140		.119	.118	.121	.122		
D	0.210	0.230		.222	.221	.223	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.251	1.250	1.250	1.250		
G	5.990	6.010		6.002	6.002	6.003	6.002		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.679	1.679	1.680	1.679		
J	2.495	2.505		2.501	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.239	.239	.239	.237		
N	0.100	0.140		.122	.120	.120	.123		
O	0.540	0.560		.551	.550	.550	.550		
P	0.490	0.510		.501	.499	.500	.499		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.253	.253	.253		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.138	1.134	1.138		
W	1.565	1.585	DT8695 A/B						
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.  
Date: 06/06/16

Audited by: JML  
Date: 06/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	27111
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2666-2
<b>Inspection Dwg:</b> D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

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				1	2	3	4		
A	0.100	0.140		.119	.118	.119	.119		
B	0.100	0.140		.117	.120	.121	.121		
C	0.100	0.140		.122	.121	.121	.121		
D	0.210	0.230		.225	.225	.225	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.001	6.001	6.001	6.001		
H	0.510	0.515		.514	.514	.514	.514		
I	1.674	1.684		1.679	1.679	1.679	1.675		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.124	.122	.124	.122		
O	0.540	0.560		.548	.549	.548	.548		
P	0.490	0.510		.497	.498	.498	.495		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.251	.251	.251	.252		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.136	1.136	1.137	1.135		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA
Date:	06.06.19

Audited by:	RM
Date:	06/06/21

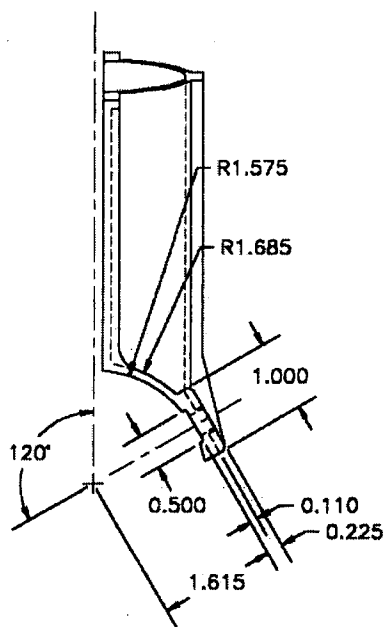
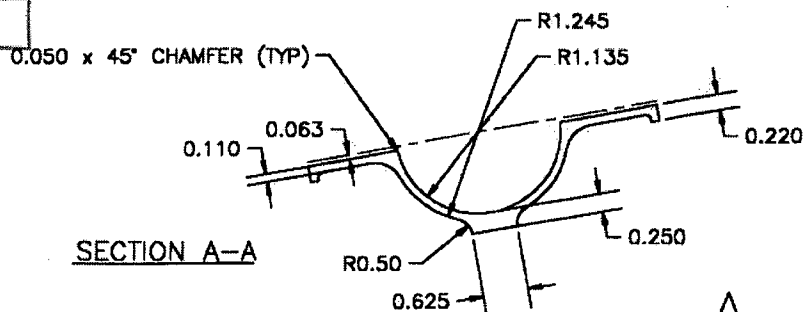
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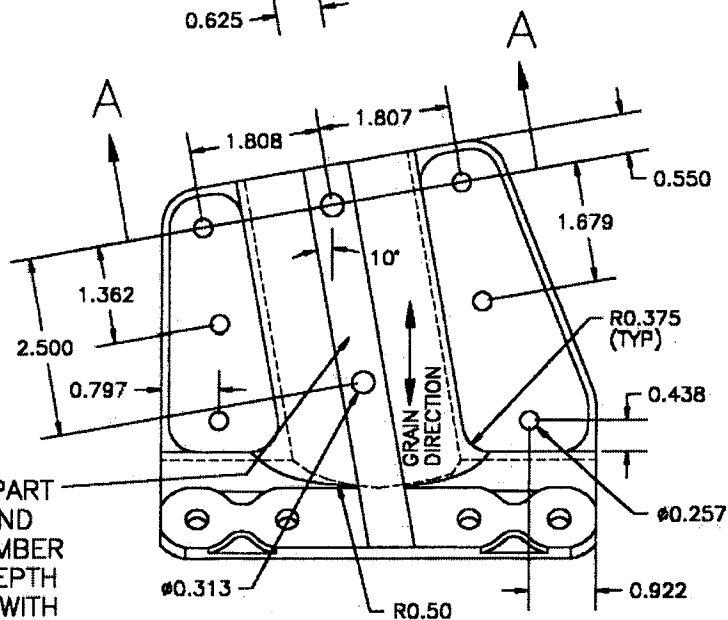


DESIGN <i>mm</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>mm</i>	APPROVED <i>KS</i>	DRAWING NO. D2666	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD INSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	

EFFECTIVE	DEOs
9095	9122
97/11/06 DS	98/12/14
9102	
98/05/04 DS	



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



RELEASED  
97/07/16 DS  
ECN 008

0.050 x 45° CHAMFER  
ALL AROUND

MATERIAL: ~~7075-T651~~ OR 7075-T7351 (QQ-A-250/12)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2  
NOTE: D2666-1 SHOWN (D2666-2 IS OPPOSITE)  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27111